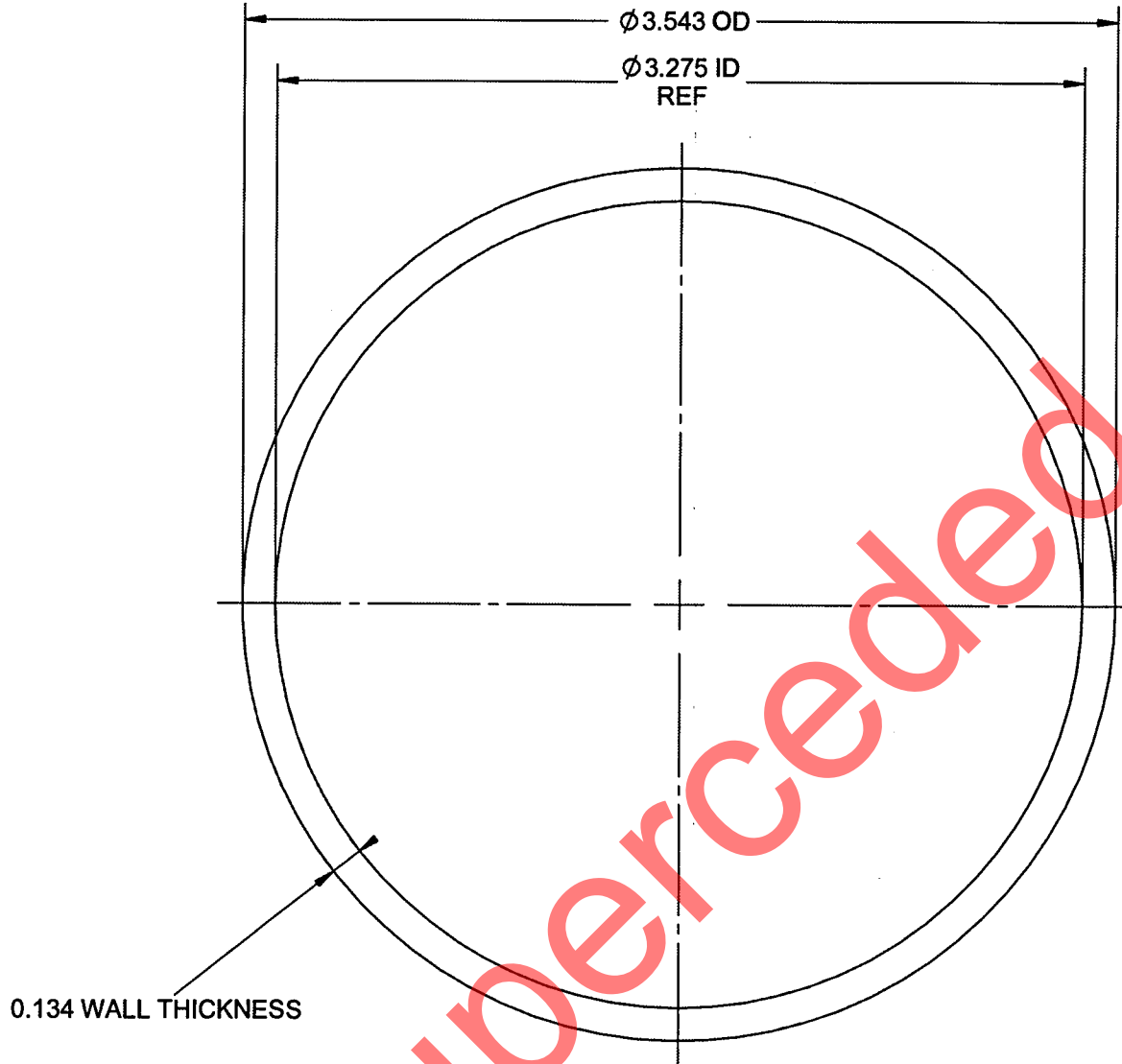


SPECIFICATION CONTROL DRAWING



D6025-XXX CROSSTUBE MATERIAL

WHERE XXX IS LENGTH IN INCHES
EG. 103" LONG TUBE: D6025-103

NOTES:

- 1) MATERIAL: 3.543 OD X 0.134 WALL 7075-T73/T73510/T73511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11 OR ASTM B210 OR ASTM B241) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 68 KSI
MINIMUM YIELD TENSILE STRENGTH = 58 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER ANSI H35.2 AS FOLLOWS:
O.D.: +/- 0.015 MEAN (+/- 0.030 INCLUDING OVALITY)
WALL: +/-0.013 MEAN (+/- 0.013 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.500/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AS SOON AS POSSIBLE ONCE MATERIAL IS RECEIVED FROM SUPPLIER. CHEMICAL CONVERSION COAT MUST BE CARRIED OUT BEFORE SENDING THE EXTRUSION TO AN OUTSIDE VENDOR.

B	ADDED NOTE 9	ML	17.01.20
A	NEW ISSUE	ML	16.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. B
MFG. APPR.	LL	D6025	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CROSSTUBE MATERIAL	NTS
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2017-02-10

APPROVED